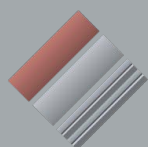
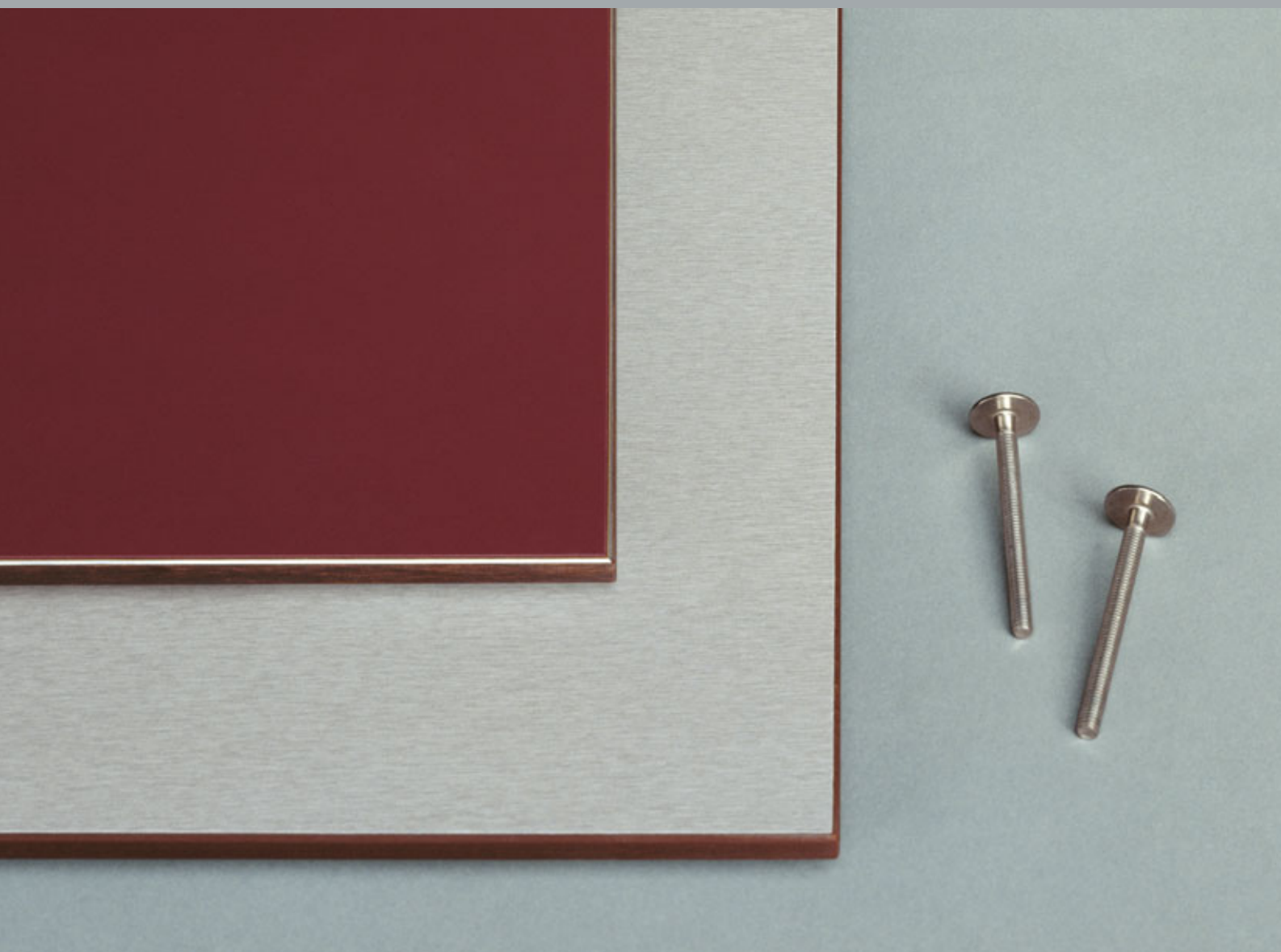


the max.

ATI 7

MAX EXTERIOR for balconies and railings



MultiClad
Facade Systems

Exterior

MAX
o n t o p


Published so far in our Technical Information Series are:

- TI 1: Recommendations for Tender Texts
- TI 3: Working with MAX Compact Panels and MAX Compactforming Elements
- TI 4: Cubicle Construction with MAX Compact panels and MAX Compactforming Elements
- TI 5: Building Furnishings and wall protection with MAX Compact Panels and MAX Compactforming Elements
- TI 6: Physical Properties, Behaviour in Fire, Chemical Resistance and Cleaning of MAX Laminate Panels (HPL), and MAX Compact Panels (HPL)
- TI 7: MAX EXTERIOR, for Balconies and Railings
- TI 9: MAX Metal Panels
- TI 10: General Working Guidelines for MAX Laminate Panels (HPL)
- TI 11: Railing Fillers made from MAX Compact panels and MAX Compactforming Elements
- TI 12: MAX EXTERIOR, Outside Wall Cladding
- TI 16: Tender Texts for Cubicles and Shower Units made from MAX Compact Panels
- TI 18: MAX Alumax, MAX Aluphenol and MAX Alucompact

Please file this Technical Information brochure in your MAX EXTERIOR folder

* = Changed from last issue

This Technical Information brochure relates to the products MAX EXTERIOR and Universal

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EXTERIOR and the Environment

MAX EXTERIOR consists of lengths of natural fibre - about 65 % of the weight - and synthetic resins. The panels contain no organic halogen (chlorine, fluorine, bromine etc.) compounds, such as occur in propellant gases or PVC. They contain neither asbestos nor wood preservatives (fungicide, pesticide etc.) and are free from sulphur, mercury and cadmium. The precisely managed production processes have no negative effects whatsoever on the environment.

The shavings which arise when machining (cutting and milling) are not hazardous to health. Consequently, even with the thermal disposal of waste - assuming modern heating plants - no environmental poisons such as hydrochloric acid, organic chlorine compounds or dioxins can arise.

MAX EXTERIOR breaks down - with appropriately high combustion chamber temperatures and dwell times of the combustion gases in the combustion chamber, as well as an adequate supply of oxygen - into carbon dioxide, nitrogen, water and ashes. The energy which results from this can be utilised.

Disposal on well-ordered commercial landfills is not problematic. Always observe the country-specific rules and regulations which apply to disposal.

MAX EXTERIOR is a high-quality building product, which - as a large-format, flat panel - is used specially for durable balcony and facade cladding.

MAX EXTERIOR panels are duomer high-pressure laminates (HPL) conforming to EN 438 Type CGS with additional, extremely effective, weather protection. They are produced in lamination presses at great pressure and high temperature from lengths of natural fibre which have been impregnated with synthetic resin. As a result of the described production process - which has no negative effects on the environment - MAX EXTERIOR panels have the following excellent properties:

- High weather resistance
- Optimal light-fastness
- Scratchproof
- Even better solvent resistance
- Impact resistant
- Resistant to adverse environmental influences (acid rain)
- High mechanical strength (no risk of breaking)
- Self-supporting
- Bending resistant
- Impact proof
- Vandal proof
- Decorative
- Resistant to contamination by animals (urine resistant)
- Easy to clean (e.g. spray graffiti)
- Resistant to water and steam
- Non-corroding and durable
- Frost insensitive
- Heat insensitive
- Physiologically harmless and environmentally friendly
- Free from organic halogen (chlorine, fluorine, bromine) and sulphur compounds
- Free from heavy metals
- Asbestos-free
- Non-drip burning
- Low smoke emission in the event of fire
- Can be worked with joinery equipment without problem
- No work dust which is harmful to health
- Easy to install
- No maintenance necessary

Weather protection and surface quality:

Highly compressed acrylate-polyurethane resins form a sealed surface layer which gives lasting protection to the decorative layer underneath. "ACID RAIN" caused by the emission of pollutants does not attack the panel surface. MAX EXTERIOR panels have been in use for over two decades and have proved themselves. (Report of the Austrian Plastics Institute [Österreichischen Kunststoffinstitutes] no 39.886/1 dated 1998.12.18).

Warranty

ISOMAX warrants the quality of MAX EXTERIOR within the framework of the given values and test standards. However, they are expressly not liable for defects in the substructure or defective installation as they have no control over the execution of these. The local building regulations are to be followed without fail - we accept no liability with regard to these. All information corresponds to the current state of the technology. Suitability for particular applications cannot be confirmed in general.

Application areas of MAX EXTERIOR



Fig. 1



Fig. 2



Fig. 3



Fig. 4



Fig. 5



Fig. 6

A

MAX EXTERIOR panels are B1 fire resistant, Q1 low smoke emitting, and TR1/ non-drip in accordance with Test Report No. 37.338 of the Austrian Plastics Institute [Österreichischen Kunststoffinstitutes]. Panel thickness 2-10 mm.

CH

Fire classification 5 (200 °C).3 for 6-13 mm MAX EXTERIOR Type CGF-VKF Permit No. 9683

D

MAX EXTERIOR panels Type CGF in thicknesses of 6 -10 mm are B1 in accordance with DIN 4102 and have the General Building Construction Supervision Permit from the Institute for Construction Technology [Institut für Bautechnik], Berlin.
Permit Number: Z-33.2-16

MAX EXTERIOR has passed the test for balcony railings in accordance with ETB guidelines.
Test Certificate No. 974143-MKLi

Basics:

During construction and installation, care is to be taken that the material is not exposed to standing water. This means that the panels must always be able to dry out.

Connections of MAX EXTERIOR panels to one another always have to be made in the same panel direction.

MAX EXTERIOR can show deviations from being flat and this is to be compensated for by the subconstruction being executed so that it is stable and flat. All connections to other components or to the background must be executed firmly. Elastic intermediate spacers to the subconstruction elements and also between subconstruction elements which permit a greater tolerance than ± 0.5 mm must definitely be avoided.

Panel joints should be reinforced from behind or should be held level by suitable connections, e.g. tongue and groove or H-profile, which allow an appropriate expansion clearance.

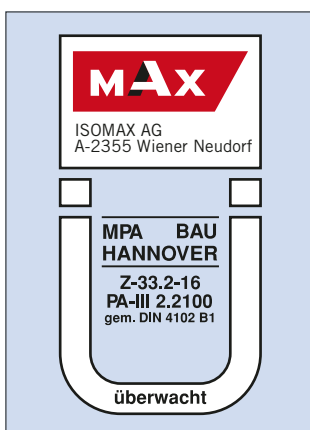


Fig. 7

Transport and Handling

- Handle MAX EXTERIOR panels with care in order not to damage the edges and surfaces of the high-quality material. In spite of the excellent surface hardness and the installation protection film, the stack weight of MAX EXTERIOR is a possible cause of damage. Therefore, any form of dirt or dust between the panels must definitely be avoided.
- MAX EXTERIOR must be secured against slippage during transport. When loading or unloading, the panels must be lifted. Do not push or pull them over the edge.
- Transport protection films must always be removed from both sides at the same time. The transport protection film must not be exposed to heat or direct sunshine.

Storage and Air Conditioning

- MAX EXTERIOR must be stacked horizontally on flat, stable supports and supporting panels. The goods must lie completely flat.
- Cover plates must always be left on the stack. The top cover should be weighted down.
- After removal of panels, PE films must again be closed over the stack.
- The same applies, in principle, for cut-panel stacks.
- Incorrect storage can lead to permanent deformation of the panels.
- MAX EXTERIOR is to be stored in closed rooms under normal climatic conditions.
- Climate differences on the two surfaces of a panel are to be avoided.
- With pre-installed fastening elements, therefore, care is to be taken that the climatic effect is uniform on all sides. Use intermediate layers of wood or plastic.

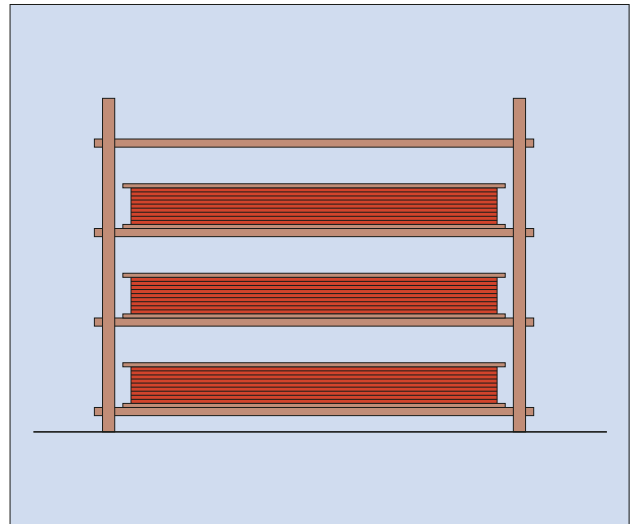


Fig. 8

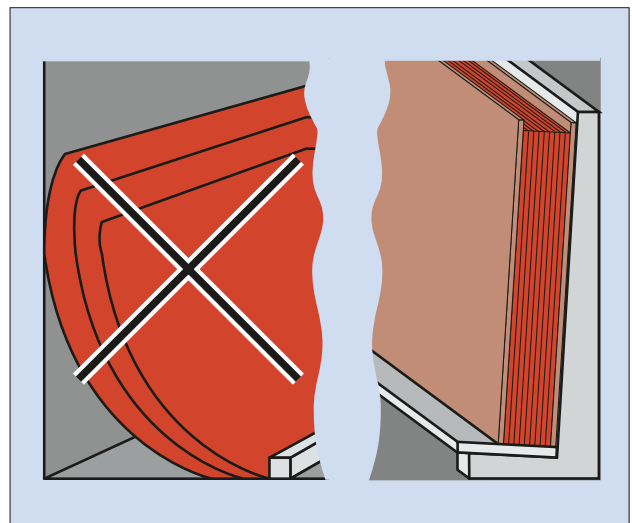


Fig. 9

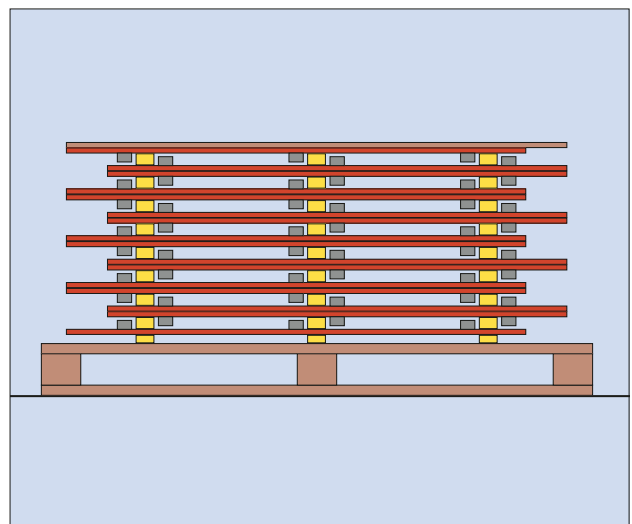


Fig. 10

Machining

MAX EXTERIOR can be easily machined, like hardwood, laminated chipboard or bonded chipboard, with carbide-tipped woodworking tools.

Saw with stable circular saws or hand-held circular saws for installation cutting. All well-known producers of hand-held machines (Festo, Bosch, Metabo and many more) offer guide rails.

Carbide-tipped saw blades with (group) trapezoidal teeth FZ/TR - see Figure 12 (e.g. Leitz) have produced good results. To achieve good cutting quality, feed EXTERIOR as smoothly as possible.

Cutting rate:

50-60 m/sec depending on tool diameter and rpm, e.g.

4000 rpm, Ø 250 mm, 64 teeth.

Depth of cut per tooth: 0.02 - 0.04 mm

Feed: 6 - 10 m/min depending on thickness.

Sharp saws and optimum setting of the saw blade projection are necessary in order to achieve clean cut edges.

For fitting work and chamfering on the construction site, electrical hand planes with a chamfering or a mitring groove have proven themselves.

Use HSS twist drills for manual drilling. Drill tip $\leq 90^\circ$. When using carbide-tipped drills use pillar drilling machines - carbide metal tends to break off when drilling by hand.

Please see our Technical Information No. 3 for further and more detailed working recommendations.

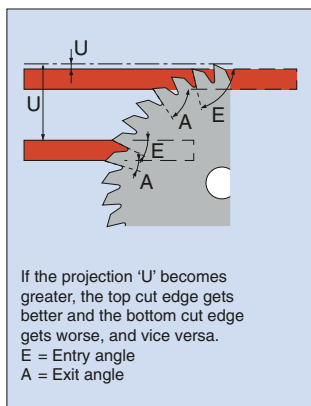


Fig. 11

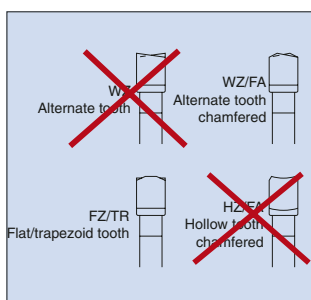


Fig. 12

Cleaning

MAX EXTERIOR has a hygienic, sealed surface - it needs no looking after. Cleaning is necessary under certain circumstances. This is most easily done as follows:

for cleaning use clean, warm water, clean cloths or rags, and soap (household cleaners which are sold in shops). Avoid scouring substances.

■ For EXTERIOR NT and UNIVERSAL surfaces, solvent cleaners can be used for removing stubborn marks such as varnish, paint sprays (graffiti) etc.

■ Caution: Never use solvent or cleaners containing solvent for the EP surface included in earlier collections. Severe marks can be dealt with quickly with isopropyl alcohol.

Material Characteristics and Expansion Clearances

MAX EXTERIOR shrinks when it loses moisture!

MAX EXTERIOR expands when it absorbs moisture!

When working and constructing with the panels, thought must be given to this possible dimensional change. For EXTERIOR it is basically half as much lengthways as widthways (lengthways is relative to the nominal panel format!).

Metal subconstructions change their dimensions with differences in temperature. The dimensions of MAX EXTERIOR, however, alter under the influence of changing relative humidity. These changes in size of subconstruction and cladding material can be opposite to each other. When installing, therefore, attention must - without fail - be paid to the expansion clearance.

The rule of thumb for the required expansion clearance is:

Element length = a

Element width = b

$$\frac{a \text{ or } b \text{ (in mm)}}{500} = \text{Expansion clearance}$$

Fastening Points

Fixed and sliding points have to be formed (Fig. 21)

Sliding point

The diameter of the drill hole in MAX EXTERIOR must be drilled larger than the diameter of the fastening, depending on the required expansion clearance. This is the shaft diameter of the fastening plus 2 mm for every meter of cladding material starting from the fixed point. The head of the fastening must be big enough so that the drill hole in MAX EXTERIOR is always covered. The fastening is placed in such a way that the panel can move.

Rivets are put in place with flexible mouth-pieces. The defined clearance of the rivet head, allows movement of the elements in the drill hole. Clearance + 0.3 mm (Fig. 21).

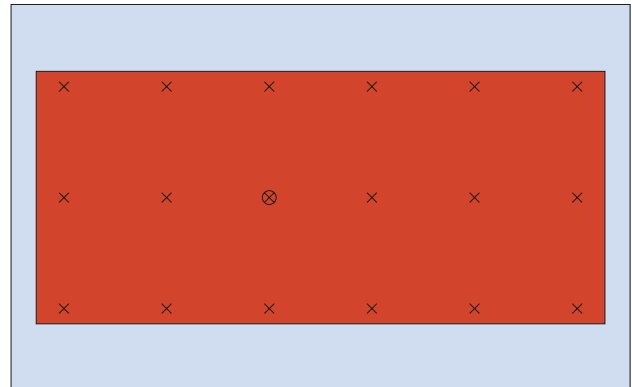
Screws must not be over-tightened. Do not use any countersunk screws - use washers if necessary. The centre point of the drill hole in the subconstruction must coincide with the centre point of the drill hole in MAX EXTERIOR. Drill with a centring piece! The fastenings should be put in place starting from the middle of panel outwards.

Fixed point

Fixed points are used for uniform distribution (halving) of the expansion and shrinkage movements. The diameter of the drill hole in MAX EXTERIOR is the same size as the diameter of the fastening.

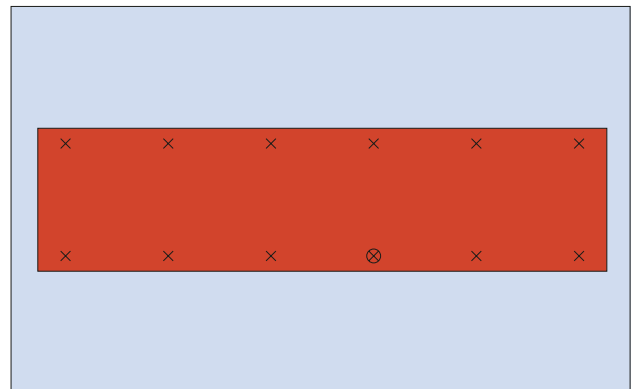
Panel Joints

The joints must be made at least 8 mm wide so that changes in size can take place without hindrance.



Double span panel

Fig. 13



Single span panel

Fig 14

⊗ Fixed point x Sliding point

Fastenings made of non-corroding materials must always be used.

MAX EXTERIOR Installation Screw

with covering cap for wooden subconstructions.

Installation screw and washer made of stainless steel CrNiMo 17122

Material no. 1.4401

Diameter of drill hole in the MAX EXTERIOR panel:

Sliding points: 8 mm or as required

Fixed points: 6.0 mm

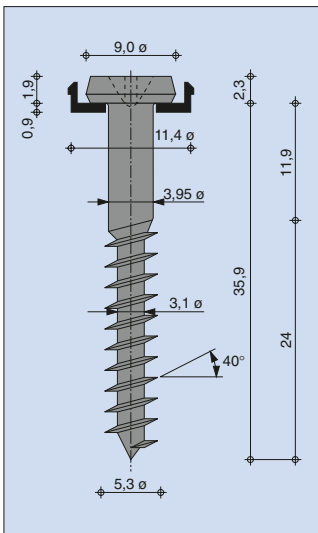


Fig. 15

MAX EXTERIOR Installation Screw

with Torx 20 made of stainless steel X5Cr Ni Mo 17122

Material no. 1.4401 V4A

Lacquered head on request.

Diameter of drill hole in MAX EXTERIOR Sliding points:

8 mm or as required

Fixed points: 6.0 mm

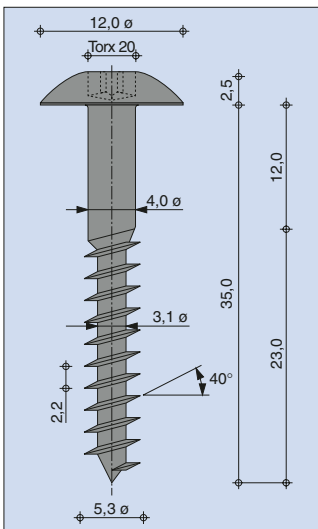


Fig. 16

MAX EXTERIOR Balcony Screw with covering cap for metal sub-constructions.

M5 balcony screw with washer, spring washer and cap nut of stainless high-grade steel, washer between MAX EXTERIOR panel and subconstruction made of polyamide.

Diameter of drill hole:

MAX EXTERIOR:

Sliding points + Fixed points

Subconstruction:

Sliding points: 8 mm

Fixed points: 6.0 mm

Screw length = Clamping thickness + ≥ 9 mm

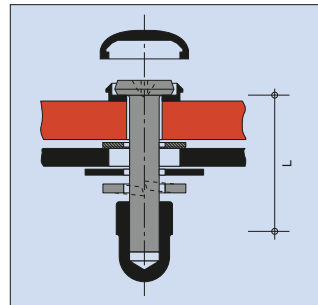


Fig. 17

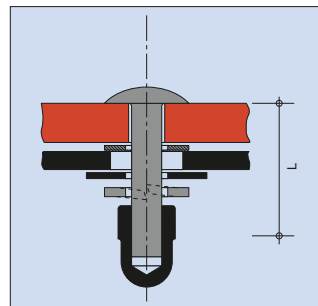


Fig. 18

Aluminium blind rivet with big head colour lacquered or with covering cap for metal subconstructions.

Rivet sleeve: Al Mg 3, Material no. 3.3535
 Rivet pin: Steel, Material no. 1.4541
 Snapping force of rivet pin: *5.6 KN
 Diameter of the drill hole in the EXTERIOR panel.
 Sliding points: 8.5 mm or as required.
 Fixed points: 5.1 mm
 Diameter of drill hole in the metal subconstruction: 5.1 mm

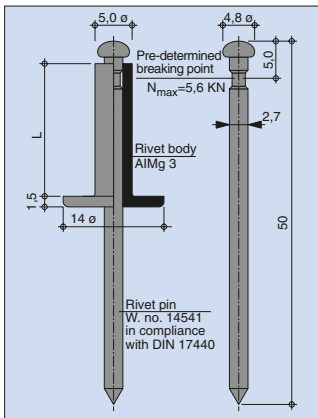


Fig. 19

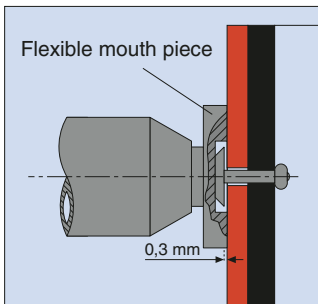
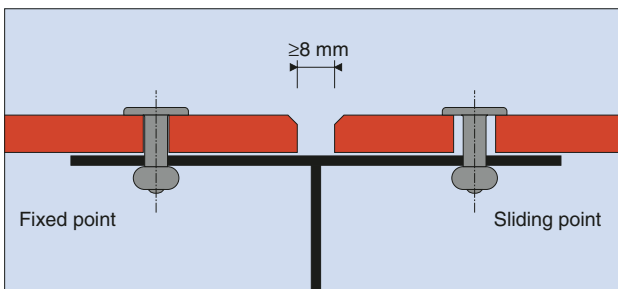


Fig. 20

The rivets must be put in place with a flexible mouthpiece, clearance 0.3 mm.



Example of a vertical joint

Fig. 21

Suppliers of Fastenings:

MAX EXTERIOR installation screws, MAX EXTERIOR balcony screws, aluminium blind rivets and flexible mouthpieces are sold:

in Germany by:

MBE GmbH, D-58706 Menden, Tel. (+49) 23 73/4304-35
 Fax: (+49) 23 73/18855

in Austria by:

UNI Bausysteme GmbH, Gewerbepark 1, A-4052 Ansfelden
 Tel. (+43) 72 29/78 990-0, Fax: (+43) 72 29/78 995
 E-mail: verkauf@unibausysteme.at

Aluminium glass mounting brackets screwed to metal structural tubes.

Clamping elements are sold in appropriate specialist hardware stores. Clamping jaws should have securing pins which prevent the filler elements from falling if the clamp should slacken.

Längle, A-6840 Götzis
 Smejkal, A-1230 Vienna
 HLK, A-1100 Vienna
 Pauli, D-51536 Waldbröl
 SWS, D-51538 Waldbröl
 QTEC, D-06749 Bitterfeld

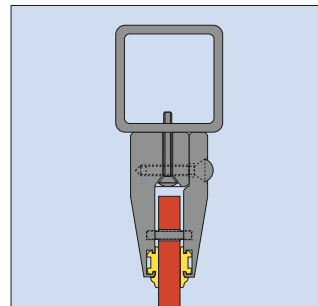


Fig. 22

Fastening and Edge Spacing - Variants

The railing installation variants shown here have been tested at the University of Technology, Hanover in accordance with the ETB guidelines for "Building Components which Safeguard against Falls, June 1985" and passed.

$F1 \leq 120$ mm

$F2 \leq 40$ mm

Projecting ends E

- for 6 mm panels: $20 \text{ mm} \leq E \leq 120$ mm
- for 8 mm panels: $20 \text{ mm} \leq E \leq 200$ mm
- for 10 mm panels: $20 \text{ mm} \leq E \leq 250$ mm

* The height of the railing must comply with the local building regulations.

e.g. Vienna

Up to the 4th floor, the height of the railing must be at least 1000 mm.

As from the 5th floor, 1100 mm.

A) MAX EXTERIOR riveted panels Riveting done as described on page 13.

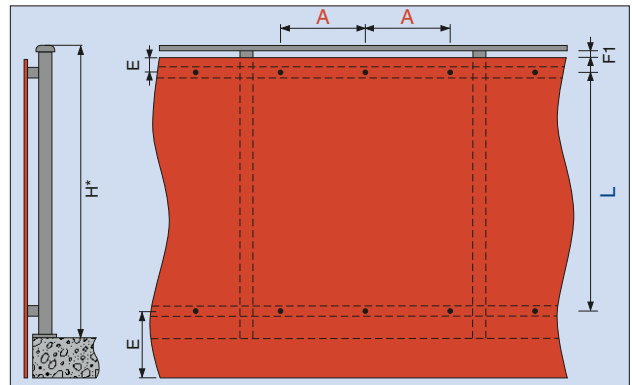


Fig. 23

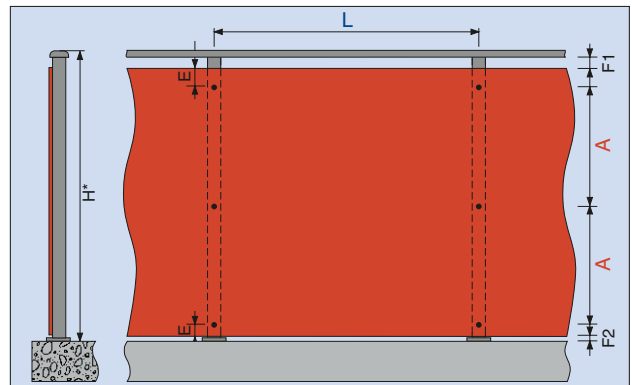


Fig. 24

Panel thickness in mm		Height of railing* $H = 900 - 1100$ mm = Maximum fastening spacing
6 mm	A	350
	L	800
8 mm	A	350
	L	950
10 mm	A	400
	L	1000

B) MAX EXTERIOR screwed panels
Balcony screws as described on page 12

- $F1 \leq 120 \text{ mm}$
 $F2 \leq 40 \text{ mm}$
 Projecting ends E
 - for 6 mm panels: $20 \text{ mm} \leq E \leq 120 \text{ mm}$
 - for 8 mm panels: $20 \text{ mm} \leq E \leq 200 \text{ mm}$
 - for 10 mm panels: $20 \text{ mm} \leq E \leq 250 \text{ mm}$

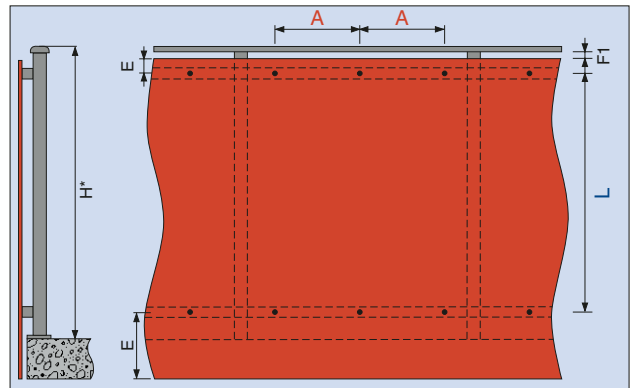


Fig. 25

* The height of the railing must comply with the local building regulations.

e.g. Vienna
Up to the 4th floor, the height of the railing must be at least 1000 mm. As from the 5th floor, 1100 mm.

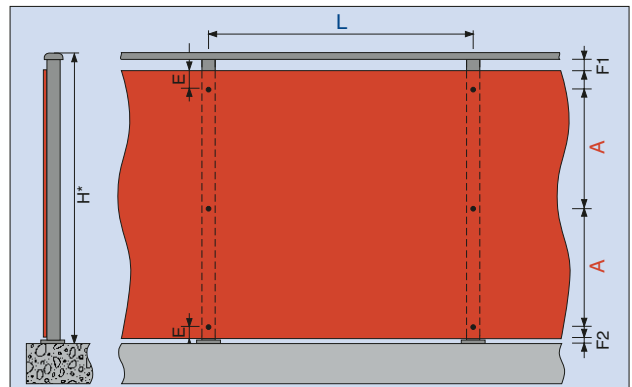


Fig. 26

Panel thickness in mm		Height of railing* H = 900 - 1100 mm = Maximum fastening spacing
6 mm	A	450
	L	850
8 mm	A	500
	L	1000
10 mm	A	550
	L	1100

C) MAX EXTERIOR aluminium compact panel - screwed
Balcony screws as described on page 12

F1 ≤ 120 mm
F2 ≤ 40 mm
Projecting ends E
- for 6 mm panels: 20 mm ≤ E ≤ 250 mm

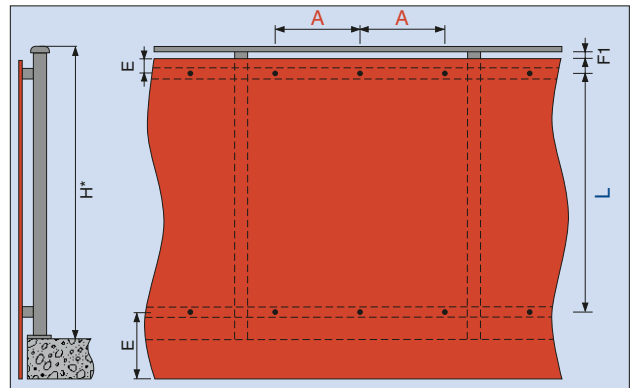


Fig. 27

* The height of the railing must comply with the local building regulations.

e.g. Vienna
Up to the 4th floor, the height of the railing must be at least 1000 mm. As from the 5th floor, 1100 mm.

Description:
MAX EXTERIOR aluminium Compact panels each have an aluminium band positioned below the décor layer. These aluminium bands give an extremely high breaking strength and stiffen the panel. Due to this, very large fastening spacings are possible with low material thicknesses. The working and machining is to be carried out as for the MAX EXTERIOR panels.

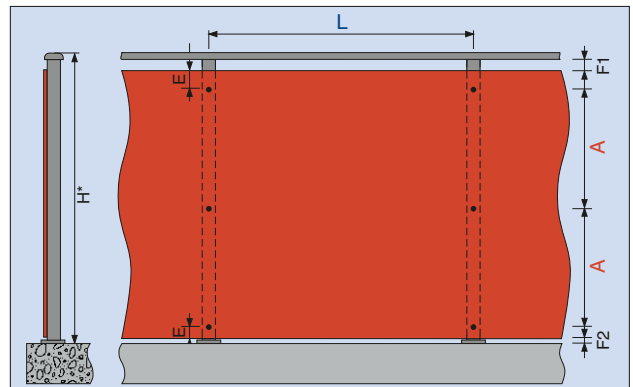


Fig. 28

Technical data:

Thickness	6 mm
Weight	9.1 kg/m ²
Flexural strength	200 Mpa
Flexural elasticity modulus	18000Mpa
Fire behaviour	
ÖNORM	
B-3800 T1	B2
DIN 4102	B2

Panel thickness in mm	Height of railing* H = 900 - 1100 mm = Maximum fastening spacing
6 mm	A 500
	L 1350

D) MAX EXTERIOR aluminium compact panels - perforated and screwed. Balcony screws as described on page 12

F1 ≤ 120 mm
 F2 ≤ 40 mm
 Projecting ends E
 - for 6 mm panels: 20 mm ≤ E ≤ 250 mm

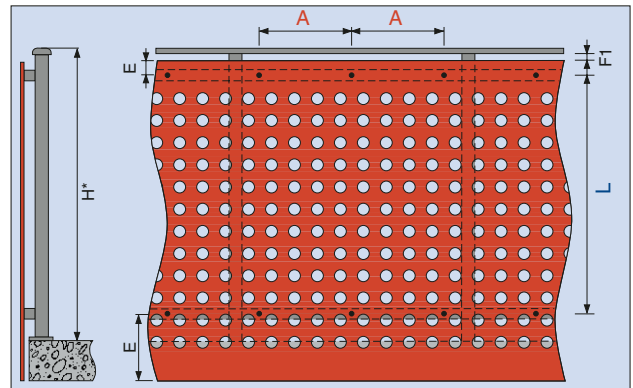


Fig. 29

* The height of the railing must comply with the local building regulations.

e.g. Vienna
 Up to the 4th floor, the height of the railing must be at least 1000 mm. As from the 5th floor, 1100 mm.

Due to the extremely high breaking strength, it is also possible to execute these MAX EXTERIOR aluminium compact panels perforated. This is normally done by milling with CNC machines. The fastening spacings given in the table relate to hole patterns for which the remaining webs ≥ the hole diameter. This variant is ETB tested. The holes must not provide climbing assistance for small children. If you have any questions, please contact our Application Engineering Department.

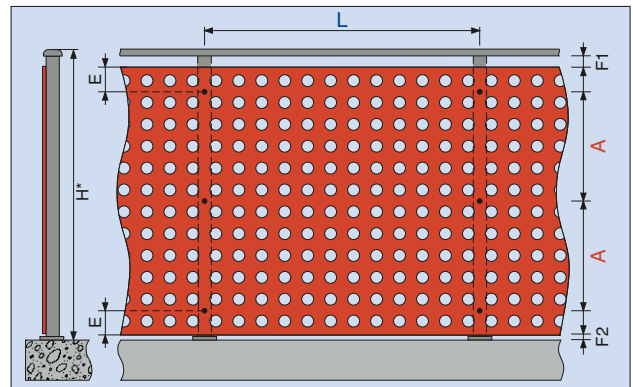


Fig. 30

Panel thickness in mm	Height of railing*
	H = 900 - 1100 mm = Maximum fastening spacing
6 mm	A 450
	L 1000

**E) MAX EXTERIOR panels with clamping sections fixed
(glass mounting brackets)**

$F1 \leq 120 \text{ mm}$
 $F2 \leq 40 \text{ mm}$
 $20 \text{ mm} \leq E \leq 20 \times \text{Panel thickness}$
 $G \geq 35 \text{ mm}$

At least 3 fastening points must be positioned per side.

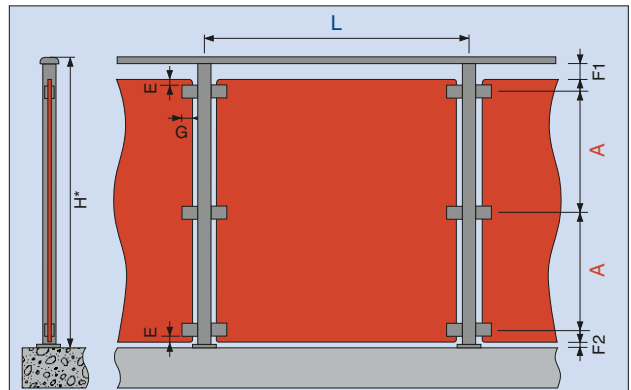


Fig. 31

* The height of the railing must comply with the local building regulations.

e.g. Vienna
 Up to the 4th floor, the height of the railing must be at least 1000 mm. As from the 5th floor, 1100 mm.

Panel thickness in mm	Height of railing* H = 900 - 1100 mm = Maximum fastening spacing	
8 mm	A	450
	L	950
10 mm	A	500
	L	1100
13 mm	A	550
	L	1150

F) MAX EXTERIOR panels with aluminium edge strips fixed. Dimensioning according to structural engineering requirements

- F1 ≤ 120 mm
- F2 ≤ 40 mm
- B ≥ 1300 mm = Length of element
- P ≥ 28 mm Width of profile
- D ≥ 8 mm Expansion gap

Attention must be paid to the drainage of the bottom profile.

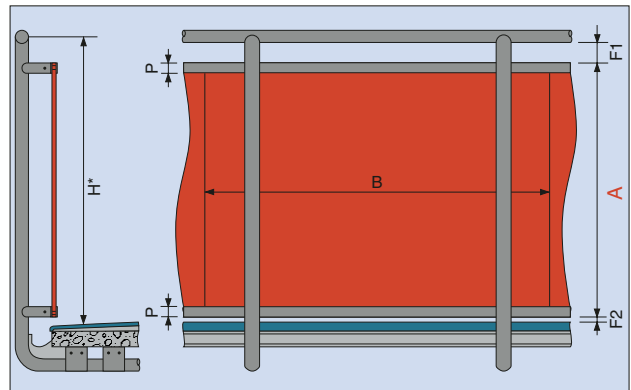


Fig. 32

* The height of the railing must comply with the local building regulations.

e.g. Vienna

Up to the 4th floor, the height of the railing must be at least 1000 mm. As from the 5th floor, 1100 mm.

Panel thickness in mm	Height of railing* H = 900 - 1100 mm = Maximum fastening spacing
6 mm	A 950
8 mm	A 1150

G) Curved balcony with MAX EXTERIOR panels and metal edge strips. Dimensioning according to structural engineering requirements. Radius at least 3 m

The top and bottom edge profiles (2 mm thick) must be pre-bent. Only sliding line fastenings are allowed (no point fastenings). The straight ends and joints of the exterior panels must likewise be edged. (U-profile, H-profile).

- F1 ≤ 120 mm
- F2 ≤ 40 mm
- B ≥ 1300 mm = Length of element
- P ≥ 28 mm Width of profile

* The height of the railing must comply with the local building regulations.

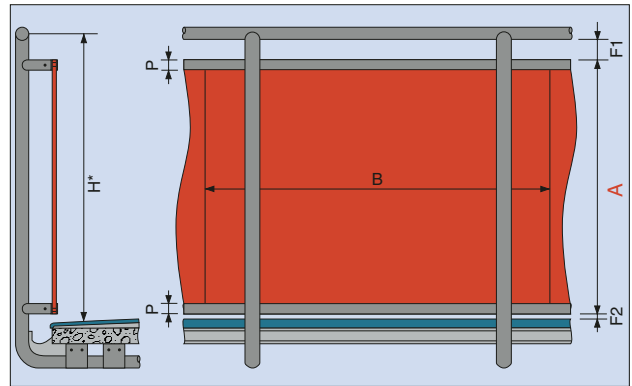


Fig. 33

* The height of the railing must comply with the local building regulations.

e.g. Vienna
Up to the 4th floor, the height of the railing must be at least 1000 mm. As from the 5th floor, 1100 mm.

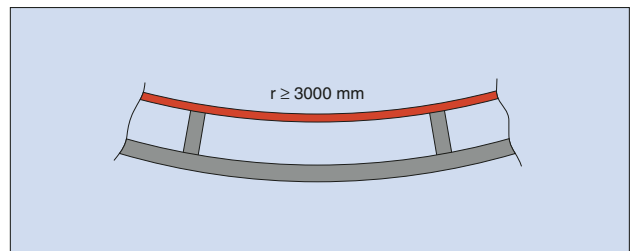


Fig. 34

Panel thickness in mm	Height of railing*
6 mm	H = 900 - 1100 mm = Maximum fastening spacing
	A 1000

MAX EXTERIOR panel

$F \geq 8 \text{ mm}$
 $20 \text{ mm} \leq G \leq 30 \text{ mm}$
 $50 \text{ mm} \leq E \leq 80 \text{ mm}$

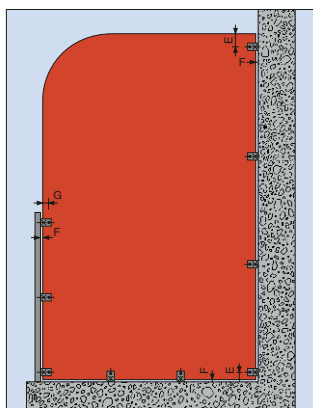


Fig. 35

Balcony dividing wall

At least 3 fastening points have to be provided on each side.

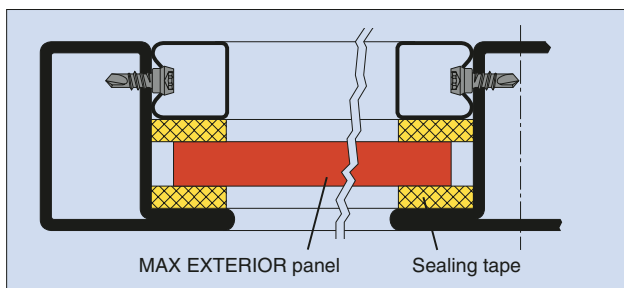


Fig. 36

Balcony dividing wall (variants)

Construction using metal rabbet pipes. MAX compact panel thicknesses according to the bay size, 6-10 mm. Dimensions of the frames according to the structural engineering requirements.

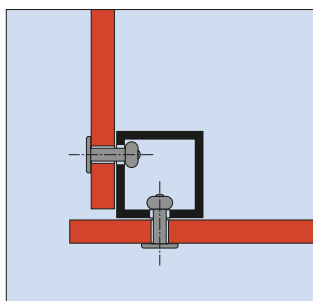


Fig. 37

Balcony corners

Especially, in some circumstances, when refurbishing with very uneven subconstructions, it is important to have the front panel protrude about 10 mm in front of the side panel. In this way, inaccuracies can be concealed from the main viewing side.



Tender recommendations for MAX EXTERIOR as Balcony filler panels

General Considerations:

The bidder is to submit a complete bid, including erection and dismantling of the scaffold, all auxiliary materials, structural engineering calculations as required, necessary cleaning and removal of the installation waste material. The carrying out of the installation must be co-ordinated and laid down with the local construction management and other organisations. The bidder is to provide safe and weatherproof storage of all the materials delivered. Erection of work huts and storage places is to be in co-ordination with the local construction management.

Technical considerations:

The subconstruction, regardless of the material or system used, has to be protected against corrosion. Anchoring elements for the installation on to the masonry and for the installation of the panels must be dimensioned in accordance with the local wind pressure load and structural engineering requirements. Proof is to be presented to the client. MAX EXTERIOR panels must be installed in accordance with manufacturer's recommendations relating to expansion clearances.

**MAX EXTERIOR
for balcony filler panels**

Text of tender

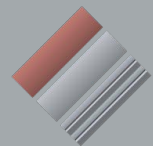
Delivery and installation of MAX EXTERIOR panels as balcony filler panels (HPL in accordance with EN 438 with additional, highly effective, weather protection).
 Thickness mm (6, 8 or 10 mm, corresponding to the structural engineering requirements).
 The filler panels are to be delivered B1 fire retardant in accordance with ÖNORM B 3800/1 or B1 low flammability in accordance with DIN 4102.
 The installation is to be done on the balcony railings described in Item with suitable fastenings in accordance with Drawing
 The edges of the MAX EXTERIOR panels are to be chamfered in the grip areas.
 Railing fillers in accordance with Drawing as described.
 Decorative surface (in accordance with the current MAX EXTERIOR range, surface NT).
 Height
 Width
 Pieces
 Price €/piece

Price reduction on the above-mentioned elements when executing the railing fillers with decorative surfaces from the UNIVERSAL range.
 price reduction per piece.

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Exterior

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